

# EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

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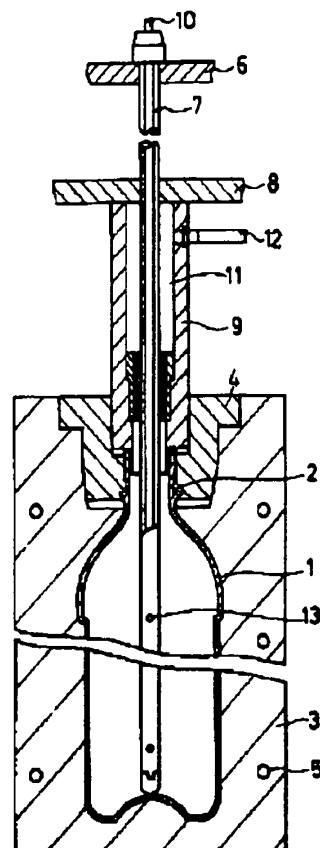
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TITLE : METHOD FOR MOLDING RESIN  
HOLLOW CONTAINER



**ABSTRACT :** PURPOSE: To obtain a molding method for preventing occurrence of residual stress and obviating the need for second dehydration of a hollow container by a method wherein just before the mold opening after the retraction of a drawing rod, the container is cooled by jetting a cooling gas out of cooling gas jet ports connecting to a cooling gas feed tube.

**CONSTITUTION:** In a method for blow molding a resin hollow container 1, a previously molded parison is put in a heated mold 3, a drawing rod 7 is brought into contact with the bottom of the parison, the parison is vertically drawn by moving the drawing rod 7 downward, a mandrel 9 for blow molding is inserted into a neck part of the parison, the parison is laterally drawn by jetting a compressed fluid through a pressurized fluid path 11 provided in the mandrel 9, and the parison is cooled and released from the mold. Just before the mold 3 opens after the drawing rod 7 is retracted, the container 1 is cooled by jetting a 10-50°C cooling gas out of a plurality of cooling gas jet ports 13 connecting to a cooling gas feed tube 10 provided in the hollow drawing rod 7.

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